

Date: Thursday, 2/22/2007 2:54:45 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 A/B STEP ASSEMBLY
Job Number	: 30803		
Estimate Number	: 10849		
P.O. Number	: <i>N/A</i>	Part Number	: D206628011
This Issue	: 2/22/2007 S.O. No. : <i>N/A</i>	Drawing Number	: <i>N/A</i>
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: <i>N/A</i>
Previous Run	: 29564	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 3/15/2007 Qty: 2 Um: Each
Checked & Approved By	: <i>[Signature]</i> 07.02.23		
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-011 CHG 002 *[Signature]*

2.0	30803A	206B STEP ASSY, LH
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Comment: Sub-Component SUB-ASSEMBLY

206B STEP ASSY, LH

D2721-041 B *30803A*

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D27313	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

✓ 2 D2731-3 Mounting Lug

~~B27420~~ B20613
 B27420 ✓

5.0	D27317	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

✓ 2 D2731-7 Mounting Lug

B28936 ✓

[Signature] 07/03/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:54:45 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY

Job Number: 30803

Part Number: D206628011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2856400

Abrasion Strip



Comment: Qty.: 1.1708 f(s)/Unit Total : 2.3415 f(s)

Pick :

Qty	Part #	Description	Batch
2	D2856-400 6.9"	Abrasion Strip	B29850

7.0

D2856400.

Abrasion Strip



Comment: Qty.: 0.5460 f(s)/Unit Total : 1.0920 f(s)

Pick :

Qty	Part #	Description	Batch
2	D2856-400 6.25"	Abrasion Strip	B29850

8.0

D3394041

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3394-041	LUG ASS,Y	B29994

9.0

D3394043

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3394-043	LUG ASS,Y	B29166 2x B28485 2x

10.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN4-15A	Bolt	M103585

11.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN4-11A	Bolt	M100743

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Thursday, 2/22/2007 2:54:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY

Job Number: 30803

Part Number: D206628011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4-12A

Bolt

1102929 ✓

13.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN960JD416

Washer

1103338 ✓

14.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21042L4

Nut (or MS21042-4)

1103349 ✓

Pat 6/3/14 (2)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-011

Location:

PPP Rev: E

Pat 6/3/14 (2)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 57.03.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____










QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:54:56 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B STEP ASSY, LH
Job Number	: 30803A		
Estimate Number	: 11698		
P.O. Number	: NIA	Part Number	: D2721041
This Issue	: 2/22/2007	S.O. No.	: NIA
Prsht Rev.	: NC	Drawing Number	: D2721 REV C
First Issue	: NIA	Project Number	: N/A
Previous Run	: 29564A	Drawing Revision	: C
		Material	: NIA
Written By	:	Due Date	: 3/15/2007
Checked & Approved By	: <u>JA 07.02.23</u>	Qty:	2 Um: Each
Comment	: Est Rev: F As Per Ecn 766 06-01-06 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Extrusion	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion <u>B9607</u>			
Check Material for any Dents or Defects FF 07-02-28 2			
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			
Comment: LARGE FABRICATION RESOURCE 1 FF 07-02-28 2			
Cut D2721-1 using D2622 extrusion as per Dwg D2721 Deburr and bevel ends for welding			
3.0	D2734	206 Step Endplate	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) 206 Step Endplate Pick: Qty Part Number Description Batch: 2 D2734 End Cap <u>B2934</u>			
JE 07-03-02 2			
4.0	D34611	PLATE	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) 206 Step Lug Pick: Qty Part Number Description Batch: 1 D3461-1 Plate <u>B29612</u>			
JE 07-03-02 2			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:54:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, LH

Job Number: 30803A

Part Number: D2721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34613

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3461-3	Plate

Batch

329611

PE 07-03-02

2

6.0

D34615

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3461-5	Plate

Batch

329614

PE 07-03-02

2

7.0

D34617

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3461-7	Plate

Batch

329616

PE 07-03-02

2

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT

followed by Jig DT

PE 07-03-02

2

A/R AL Rod

Batch:

MIC0237
MIC2225

PE 07-03-02

2

Grind end cap welds flush

PE 07-03-03

3

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

107/03/05 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:54:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, LH

Job Number: 30803A

Part Number: D2721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/05 (2)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m.l

07/03/06 (2)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-03-10

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2721 using Jig DT

followed by Jig DT

A/R AL Rod Batch: M100237

Grind End Cap Welds Flush

07-03-10

07-03-10

07-03-10

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/12 (2)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/12 (2)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Alodine

FL/ a.m

07/03/12

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LE Date: 01/03/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:54:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, LH

Job Number: 30803A

Part Number: D2721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

POWDER COATING

POWDER COATING



M103 141



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

251 / a.m 07-03-13 (2)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 07/03/13 (2)

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2721 and QSI 00 5 4.4

FR/M-1 07/03/13 (2)

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-03-13

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP 30803 07/03/13 (2)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/20 (2)

Job Completion



07-03-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

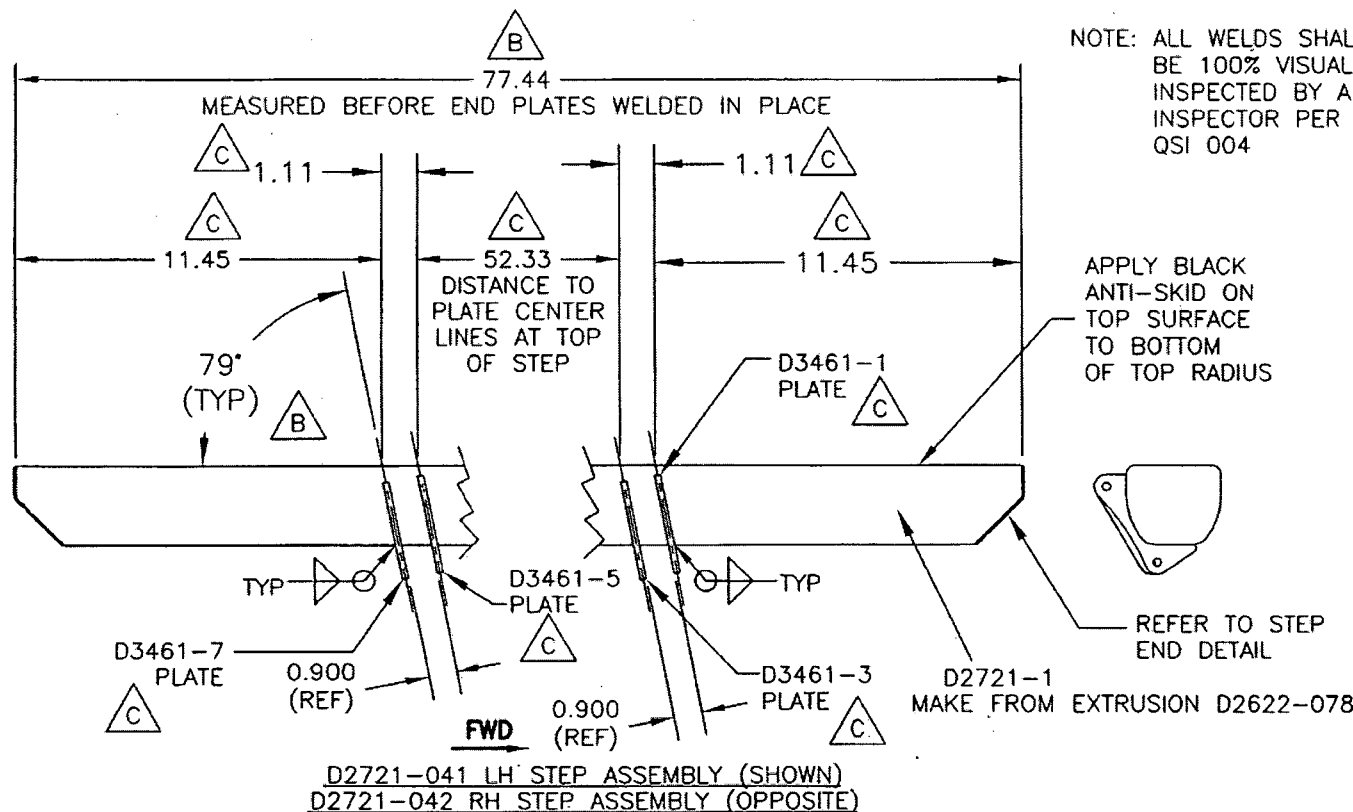
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED
05.11.14 *th*

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



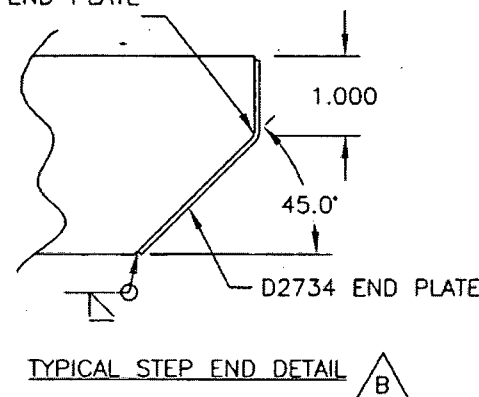
D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2721-041	LH STEP ASSEMBLY
	X	D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30803A



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DART AEROSPACE USA, INC.
PORT HADLOCK, WA

REV. C
SHEET 1 OF 1